

Work Order ID 163731

163731

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Thursday, July 06, 2017 11:11:18 AM

Item ID: D3662-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Crossbolt Spacer

Start Date: 7/11/2017 Start Qty: 24.00 *24* Cust Item ID:
 Required Date: 7/13/2017 Req'd Qty: 24.00 *24* Customer:

Reference:

Approvals: Process Plan:  Date: JUL 06 2017 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3662	Rev A								
100		0.28							DAS 23 9-89
100	Hardinge CNC LATHE SMALL					24	Ø		17/8/8
Hardinge	Memo	0.51							
Hardinge CNC Lathe Small	Machine as per Folio FA720								
110		0.00							DAS 23 9-89
110	QC2- Inspect parts off machine FAI/FAIB					24	Ø		17/8/8
QC	Memo	0.24							
Quality Control									
120		0.00							DAS 08 9-89
120	QC8- Inspect parts - second check					24	Ø		
QC	Memo	0.48							
Quality Control									

D. A. H. - 08-08

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>LG001</u>	0.00							
130						24	0		BE17-08-14
Packaging	Memo	0.24							
Packaging	***STOCK IN SKIDTUBE CELL*** LOCATION : LG001								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	2.40							
Quality Control									

DAS
21
9-89
AUG 16 2017

AUG 14 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Parent Item: D3662-1

D3662-1

Parent Item Name: Crossbolt Spacer

Start Date: 7/11/2017

Required Date: 7/13/2017

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP A08.02.04Now turned on CobraEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.625W.049		Purchased	No			100	f	1.2080	0.31	7.831579			

M6061T6T0 625W 049

**

6061-T6 RD Tube .625 x.049W

Location	Loc Qty	Loc Code	
MAT014	1.208		
(4.5625) m134528	1.208		<u>1.208</u>
(72PO) 4.5625 M138083			DAS 23 9-89 17/8/8
+ 72PO			<u>6.615</u>
↓			DAS 23 9-89 17/8/8
64.5/8 → (7.375)			

DQA: _____ Date: _____

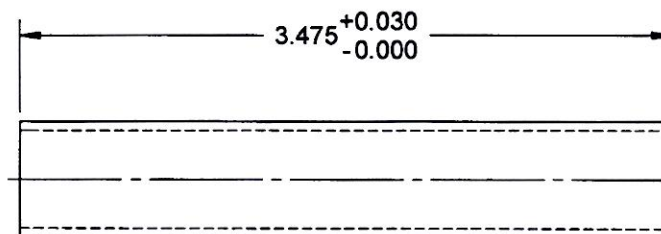
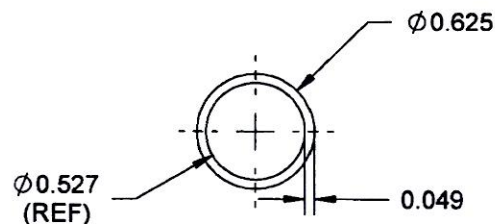


WORK ORDER NON-CONFORMANCE / UPDATE

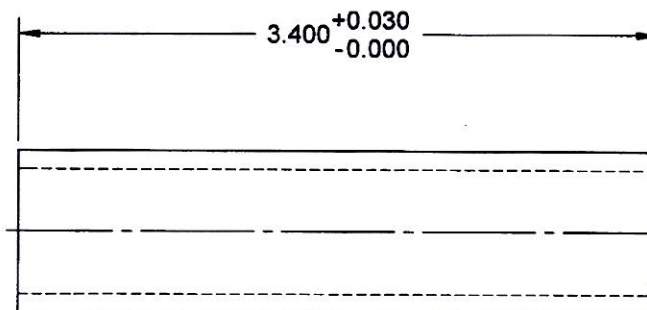
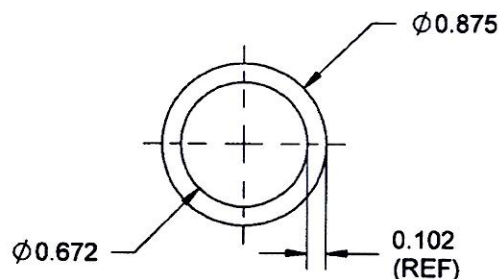
QA Closed: _____ Date: _____

Work Order update only ☐

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					



D3662-1 CROSS BOLT SPACER



D3662-3 CROSS BOLT SPACER

NOTES:

1) MATERIAL:

D3662-1 - ALUMINUM 6061-T6/T62
TUBING PER WW-T-700/6 OR AMS 4080/4082
OR QQ-A-200/8 OR QQ-A-225/8

(REF. DART MATERIAL SPEC. M6061T6T0.625W0.49)
D3662-3 - ALUMINUM 6061-T6 (OR 6061-T651/T6510/T6511/T62)
ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART MATERIAL SPEC. M6061T6RX.XXX)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D3662-1 - 0.03 LBS
D3662-3 - 0.08 LBS

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ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163731

JUL 06 2017

RELEASED
07.11.22

A	NEW ISSUE	PH	07.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3662	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		CROSS BOLT SPACER	1:1
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	